PROJECT TITLE : SPECIFICATIONS / PROCESS ASSURANCE

Period Covered : 26.6. - 22.7.1980
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Report Approved By: J.B. Boder

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0. SPECIFICATIONS - OVERALL

0.1 New PME Standard Cigarette Diameter

PME approval has been received to reduce all cigarette diameters from the old 7,95 - 8,00 (7,975) mm to the new PME standard diameter 7,95 mm, which corresponds to PM USA's 25 mm circumference. - All filters used on such cigarettes will have a diameter of 7,86 mm (old: between 7,85 and 7,90 mm). - From now on, the diameter difference of 0,09 mm between filter and cigarette will be considered as a PME standard specification.

A letter for general information has been addressed to MM. Boder, Tschudin, Stolt, Guyot, Lopes, Grünbaum, Burkhalter, Nyffeler, and Amaduzzi.

Instructions for immediate action have been released to all PME production centers, including Intertaba.

Another series of letters went to Mr Steinacher and his Area Operation Managers for clarification of the situation at the licensee production centers.

As far as known to date, the PME production centers intend to adopt the new standard diameter in August/ September, 1980.

0.2 Standard Moistures Packed Cigarettes

A PME product modification request, prepared for and discussed during the QC PME meeting of April, 1980, has been accepted by all concerned (Boder, Guyot, Nyffeler, Tschudin).

Information and instructions have been sent to all concerned. The PME production centers intend to adapt their packed cigarettes moistures to the new standards in the very near future.

The new standard packed cigarette moistures will be issued as PME standard specifications as follows:

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- Main group: 12,5 % mc packed cigarettes
  Cigarettes: Marlboro, Merit, etc.
- Ambassador group: 12,0 % mc packed cigarettes
  Cigarettes Ambassador and similar blend groups
- Exceptions group: 11,0 or 11,5 % mc
  For special blends

0.3 Method No 705

A new PME method 705, entitled "Rules for the establishment of manufacturing specifications" has been distributed in English (German and French translations in preparation). This method should complete the specification guidelines and be particularly useful for the training of persons not yet familiar with specifications.

0.4 PME Standard Specifications

Such a file is in preparation. For the moment, is contains drafts regarding the new PME standard cigarette and filter diameters, the standard packed cigarette moisture, temperatures at tobacco pre-conditioning, stacking of cases on pallets, etc.

0.5 Pack Models

Our office has started to build up a collection of packs of all products, including the licensee and L & M brands.

1. SPECIFICATIONS - PER PRODUCTION CENTER

1.1 FTR Fabriques de Tabac Réunies SA Neuchâtel

- The numbers printed on the pack have been reduced for BRS 003 (3-cigarette sample) from 7/0,6 to 6/0,5 mg and BRC/BRP 001 from 23 to 21 mg condensate.

- The bundles MEK Mercedes King Size and PMK Ph. Morris King Size are now made of a display carton which replaces the previous soft material.

- MAA 069 Ambassador, for sale in Tunisia, is a new packing version sourced from FTR.

1.2 INM Intertaba S.p.A. Zola Predosa

A new filter making spec has been prepared for the manufacture of filter MER 100 Merit, 34.2900, for sale to PMG Munich.

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1.3 PMH Ph. Morris Holland Eindhoven/Bergen op Zoom

1.4 PMG Ph. Morris Germany Munich/Berlin

- The stepwise change from velin to vergé cigarette paper on the German Marlboro has been completed in June, 1980.

- Filter paper FU-POV 40 L, replacing FU-POV 24 K, has been approved on the diluted German Marlboro.

1.5 WEL Weltab SA Bruxelles

1.6 PM UK Ph. Morris London

1.7 Licensees

- Yugoslavia:
A complete set of spec has been prepared for project Maraschino, CEH Chesterfield Filter Long (100 mm). The tobacco will be prepared in Sarajevo, the cigarette will be manufactured in Mostar.

- Greece:
The filter and cigarette making specs of the Greek MLK Marlboro King Size have been reveiwed.

- Finland:
All information has been recevied from the AOM for the modification of the two Finnish brands BEN Belmont Menthol and MLL Marlboro Lights. The expected dates of manufacture of the re-engineered cigarettes are 18.8.1980 for MLL and 1.9.1980 for BEN.

- Nigeria:
A complete set of the Nigerian filter making, cigarette making and packing specs has been received and checked. Processing specs and solution recipes are outstanding.

2. MATERIAL SPECIFICATIONS

2.1 MPP + QC PME Coordination Meeting

A reduced meeting has taken place on 10.7.1980 to settle the points for which time was too short during the June meeting.
Next meeting: 4.9.1980 in Neuchâtel.

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2.2 Submissions to Suppliers

Several submissions have been made to the firms Baumgartner (filters), Eastman (tow), Schoeller & Hoesch (filter paper), and Braunstein (cigarette paper).
Further submissions will be made shortly for tipping papers supplied by Benkert, Tann, and Malaucène.

2.3 Approvals by Suppliers

Handler & Nattermann, for internal foil.

2.4 PME File "Usage of Materials"

The sections "filter" and "cigarette" have been updated.
The section "additives TA/FA" is being reviewed.
A new group "GS glues + solvants" has been drafted.
The lists for additives and glues will newly contain complete information regarding the manufacturer (name, place) and the PME supplier or sub-contractor.

2.5 Technical Drawings

- The file for tipping papers has been updated.

- After discussions with different persons, it has been decided not to state the technical drawing numbers on the manufacturing specifications.

2.6 Panel A Approvals

- Following different problems which have turned up during the last months, it has been suggested to Leaf PME to summon a meeting with the persons directly involved.

- Our office has started to prepare a special "Panel A Approval/Refusal" file.

3. PME STANDARD RECIPES

3.1 New Recipes
MERUK-PC and MERUK-AC, production PM Holland
NW-5-AC, production FTR for sale to PM Nigeria
BEN-AC, production ATO Finland

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3.2 Modified Recipes

CC-1D-PC, CC-1F-PC, and CLI-PC, production FTR (increase of volume - water).

The complete PME standard recipe file has been reviewed and completed by the PME Material codes.

4. SPECIFICATIONS ON EDP

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5. P R O C E S S A S S U R A N C E

5.1 AccuRay

FTR's proposal made after the QC PME meeting cannot be accepted by the other production centers. A final decision will have to be made soon. However it seems to be definitely impossible to adopt a unique system in all production centers.

5.2 NTM Non-Tobacco Material Weights in Specifications

Pending.

5.3 Diameters of Filters and Cigarettes

Settled, refer to point 0.1.

5.4 Dilution

An inventory of the monthly results of all production centers has been made. The report contains results of dilution, RTD, packed cigarette moisture, total cigarette weight, and compressibility, since January, 1979, and up to May, 1980. The brands taken into consideration are MLF Marlboro Filter and MLK Marlboro King Size. This report will be distributed.

5.6 Burley Treatment

All information regarding the present Burley treatment methods (dryers and Proctor & Schwartz) are available and a report will be distributed within short.

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5.7 Kitchen and Pre- and After-cutting Solutions

Complete information collected in all PME production centers is now available to this office and a situation report will be established for the intention of all.

5.8 Production of Starch Glue

Information has been gathered in all production centers and a report for the intention of all persons interested will be prepared.

5.9 Tobacco Weights

This report is ready for distribution. It contains:
- the monthly effective tobacco weights for the cigarettes MLF - MLK - MLB - MER - MPH, from January, 1980 to May, 1980;
- the average tobacco savings, with mini and maxi savings per machine;
- the light weight rejects, with extreme deviations per machine.

5.10 New Processing Depts. PMG Berlin and PMH Bergen op Zoom

Contacts have been established with the two production centers concerned and a first meeting is expected to take place beginning August, 1980.

Thierry Bel Catherine Flury

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